

MAY 15 2018

Ph



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D412-698-023
Job Sheet 177156



Part No: D412-698-023

Job Qty: 10 ea

Part Name: Automatic Door Opener (fits LH or RH)



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/8/18

Job Tracking No:

Due Date: 6/1/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: IIN-D412-698 REV.G IPP Rev:A New Issue 07-07-12 JLM IPP rev B ecn 1207 08.07.03 EC verified by:LL

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea		6/1/18	0.00	0.00	Start Up Stores/Pkg-2		MAY 31 2018
110	Packaging	10 pcs		6/1/18	0.00	0.00	Packaging1-4		
120	QC	10 pcs		6/1/18	0.00	0.00	QC4		
125	DC	10 pcs		6/1/18	0.00	0.00	DC		
130	Packaging	10 pcs		6/1/18	0.00	0.00	Packaging3-2		
140	QC21-FG	10 Ea		6/1/18	0.00	0.00	QC21		JUN 04 2018

Part Op 125 - Photocopy bluefile & type labels per PPP D412-698-023 CHG003
Descriptions:

F9028 10x sold

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3552-11	Door Prop 3055045X1	10 Ea (1 ea)	90-Start up Operation	5073177X8 3050225X1
D3594-043	Floor Doubler Assembly, LH	10 Ea (1 ea)	90-Start up Operation	5059001X5 3059003X5
D3594-044	Floor Doubler Assembly, RH 5073848	10 Ea (1 ea)	90-Start up Operation	5060806X2
D3594-5	Doubler	10 Ea (1 ea)	90-Start up Operation	3054578
D3622-1	Ball Stud	20 Ea (2 ea)	90-Start up Operation	5075108
MS20426AD4-4	Rivet	20 Ea (2 ea)	90-Start up Operation	FM132536
MS21073L5	Anchor Nut	10 Ea (1 ea)	90-Start up Operation	5036488
NAS1149D0516J	Washer	20 Ea (2 ea)	90-Start up Operation	5007015

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3552-11	10	8	0
	D3594-043	10	17	0
	D3594-044	10	5	0
	D3594-5	10	12	0
	D3622-1	20	8	0
	MS20426AD4-4	20	1,102	0
	MS21073L5	10	24	0
	NAS1149D0516J	20	184	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	MRB (QSI042) Approval				
Descri	Completed By				
	Lead hand / Supervisor Approval Verification				
	QC / QA Coordinator Approval				

DART
 AEROSPACE
 Container No: S076800
 Part: D412-698-023
 Job No: 177156
 Serial No/Batch: S076800
 Revision: G
 Inspector: _____
 Exp Date: 05/31/2018
 Instructions: _____

 Date: 05/31/18

Dart Aerospace Ltd.
 1270 Aberdeen Street
 Peterborough, ON K8A 1K7
 TEL: 705.333.6392-5200
 Email: sales@dartaero.com
 www.dartaerospace.com

Root Cause			
Environment	☐	No	☐
Design	☐	Op	☐
Doc/Data	☐	Offs	☐
Equip/Tooling	☐	Supplier	☐
Handling/Pre	☐	Training	☐
Material	☐	Use for Testing	☐
Internal Transport	☐	Poor Information	☐
Tribal Knowledge	☐	Rushing	☐
LOA	☐	Product Improvement	☐
Substation	☐	Process Improvement	☐
Past Expiry Date	☐	Manufacturing Process	☐
Misidentified	☐	Past Due	☐
OTHER : _____			

Material Loss/Surge /Program Weld Wrong Stock Pulled Out of Sequence Off-set Mislabeled Fit/Function Misaligned/off center	Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Wave/Twist in Tube Marks/Chatter	Broken/Damage/Defect Inspection Incomplete/Unqualified Contamination Countersink Cut Too Short Instructions Incomplete/Unclear Drill Holes	Positioned Wrong Outside Dimensions Over/Under tolerance Part Incorrect Part Lost/Missing Part Moved Drawing Finish Misread Turning Sequence
--	--	--	---

*REF. ONLY***7.0 PARTS LIST – PILOT DOOR MODIFICATION KITS**

Qty -015	Qty -023	Part Number	Description
X		D412-698-015	DOOR SUPPORT KIT
	X	D412-698-023	AUTOMATIC DOOR OPENER KIT
2		D3200-1	DOOR POST BLOCK
2		D3200-3	DOOR WEDGE
2		D3201-1	DOUBLER
1		D3201-3	ANGLE
1		D3201-4	ANGLE
	1	D3552-11	GAS SPRING
	1	D3594-5	DOOR DOUBLER
	1	D3594-043	FLOOR DOUBLER ASSEMBLY, LH
	1	D3594-044	FLOOR DOUBLER ASSEMBLY, RH
	2	D3622-1	BALL STUD
	1	MS21073L5	ANCHOR NUT
	2	MS20426AD4-4	RIVET
12		NAS1149D0332J	WASHER (AN960JD10L)
	2	NAS1149D0516J	WASHER (AN960JD516L)
12		MS21042L3	NUT (OR MS21042-3)
12		MS24693-S277	SCREW